

SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 4/4/2006 1:27:44 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 26502		Part Number	: D31451	
Estimate Number	: 11479		Drawing Number	: D3145 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/2/2006	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/24/2006	
Previous Run	: N/A		Qty:	10' Um: Each	
Written By	: See Comment Below				
Checked & Approved By	: 06.04.04				
Comment	: Est. A 03.02.28 New issue KJ/RF				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"			
					
Comment: Qty.: 0.4025 f(s)/Unit Total: 4.0247 f(s) 6061-T6 Bar 2.0" x 2.0" Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) M6061T6B2.000x2.000 Batch: M17124					
2.0	BAND SAW	BAND SAW			
					
Comment: BAND SAW Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar					
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1			
					
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per Folio FA318 and Dwg D3145 Deburr and Tumble					
4.0 A	Q05 QC2	INSPECT WORK TO CURRENT STEP			
					
Comment: INSPECT WORK TO CURRENT STEP					
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1			
					
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1					

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/05/04 (1)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 06/05/04

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA - 11

ML 06/05/04

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/04 (1)

Job Completion



AC 06/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/04	3	1 piece scrap engraving too deep, and the wall too thin 1 piece scrap, too mark in the slot. .015 "deep could cause cracking. And will be too thin		Scrap, destroy, replace.				 06.05.04.
		if marks removed. Marks caused from clamping to +glt.						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26502
Description: Bracket	Part Number:	D3145-1
Inspection Dwg: D3145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JNL</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	06/05/04	Date:	06/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>